



Dart Aerospace Ltd.
1270 Aberdeen St
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K6A 1K7
Canada

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D3179-041
Job Sheet 213689



Part No: D3179-041

Job Qty: 6 pcs

Part Name: Litter Tie Down (Non-Locking)



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 10/1/20

Job Tracking No:

Due Date: 11/30/20

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG REV E IPP A1 03.01.09 Added Acid etch end alodine RF IPP Rev:B Added Powder Coat 07-07-04 JLM
IPP REV:C AS PER REV D JLM 13-05-24 VERIFIED BY:DD IPP Rev:C 08-12-10 add part list DD verified
by:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Lead Time	DAS Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier			
100	Bandsaw - 1	6 pcs			0.00	0.50	Bandsaw - 1			33 9-89 20/10/21
110	HAAS 4 Axis - B4B	6 pcs			0.37	10.91	HAAS - 1 - B4B			
							HAAS - 2 - B4B			DAS
							HAAS - 3 - B4B			33 20/10/21
							HAAS - 4 - B4B			9-89
120	QC 2	6 pcs			0.00	0.00	QC 2 - 1			
							QC 2 - 12			
							QC 2 - 14			
							QC 2 - 17			
							QC 2 - 19			
							QC 2 - 2			
							QC 2 - 20			
							QC 2 - 22			
							QC 2 - 23			
							QC 2 - 25			
							QC 2 - 32			DAS
							QC 2 - 33			33 20/10/21
							QC 2 - 35			9-89
							QC 2 - 39			
							QC 2 - 4			
							QC 2 - 40			
							QC 2 - 44			
							QC 2 - 45			
							QC 2 - 48			
							QC 2 - 49			
							QC 2 - 50			
							QC 2 - 51			
							QC 2 - 52			
							QC 2 - 57			



Container No: S307732



Part: D3179 - 041

Job No: 213689

Serial No/Batch: S307732

Revision:

Factor:

Rate:

Options: Various STC's

Date:

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				QC 2 - 62	
				QC 2 - 63	
				QC 2 - 8	
				QC 2 - 66	
				QC 2 - 64	
				QC 2 - 65	
				QC 2 - 5	
				QC 2 - 71	
				QC 2 - 73	
				QC 2 - 69	
				QC 2 - 76	
				QC 2 - 86	
				QC 2 - 83	
130 QC 8	6 pcs	0.00	0.00	QC 8 - 12	
				QC 8 - 14	
				QC 8 - 17	
				QC 8 - 20	
				QC 8 - 25	
				QC 8 - 3	
				QC 8 - 32	3 C-L 20-10-23
				QC 8 - 33	
				QC 8 - 35	
				QC 8 - 39	
				QC 8 - 4	
				QC 8 - 44	
				QC 8 - 45	
				QC 8 - 49	
				QC 8 - 58	
				QC 8 - 8	
				QC 8 - 9	
				QC 8 - 68	
				QC 8 - 67	
				QC 8 - 1 (A)	
				QC 8 - 47	
				QC 8 - 40	
				QC 8 - 52	
				QC 8 - 23	
				QC 8 - 57	
				QC 8 - 76	
				QC 8 - 61	
				QC 8 - 66	
				QC 8 - 73	
				QC 8 - 82	
140 Handfinish - 1-1 Chemical-B4B	6 pcs	0.00	0.49	Handfinish - 1 - 1 - B4B	
				Handfinish - 1 - 2 - B4B	
				Handfinish - 1 - 3 - B4B	
				Handfinish - 1 - 4 - B4B	
				Handfinish - 1 - 5 - B4B	
				Handfinish - 1 - 6 - B4B	
				Handfinish - 1 - 7 - B4B	
				Handfinish - 1 - 8 - B4B	
				Handfinish - 1 - 9 - B4B	
				Handfinish - 1 - 10 - B4B	
				Handfinish - 1 - 11 - B4B	
				Handfinish - 1 - 12 - B4B	
				Handfinish - 1 - 13 - B4B	
				Handfinish - 1 - 14 - B4B	
				Handfinish - 1 - 15 - B4B	
				Handfinish - 1 - 16 - B4B	

150 QC 7	6 pcs	0.00 0.00	Handfinish - 1 - 17 - B4B	
			Handfinish - 1 - 18 - B4B	
			Handfinish - 1 - 19 - B4B	NOV 13 2020
			Handfinish - 1 - 20 - B4B	DAS 0700 C L AON
			Handfinish - 1 - 21 - B4B	47
			Handfinish - 1 - 22 - B4B	9-89 NOV 12 2020
			QC 7 - 10	
			QC 7 - 13	
			QC 7 - 14	
			QC 7 - 15	
			QC 7 - 17	
			QC 7 - 18	
			QC 7 - 19	
			QC 7 - 2	
			QC 7 - 28	
			QC 7 - 3	
			QC 7 - 30	
			QC 7 - 34	20-11-13
			QC 7 - 36	
			QC 7 - 37	
			QC 7 - 41	
			QC 7 - 47	
			QC 7 - 48	
			QC 7 - 51	
			QC 7 - 58	
			QC 7 - 59	
			QC 7 - 60	
			QC 7 - 9	
			QC 7 - 68	
			QC 7 - 50	
			QC 7 - 67	
			QC 7 - 40	
			QC 7 - 24	
			QC 7 - 43	
			QC 7 - 61	
			QC 7 - 81	
			QC 7 - 76	
			QC 7 - 79	
			QC 7 - 83	
			QC 7 - 82	
			QC 7 - 87	
160 Powdercoat - 1 White Gl(A)- B4B	6 pcs	0.00 0.36	Powdercoat - 1 - B4B	
			Powdercoat - 2 - B4B	
			Powdercoat - 3 - B4B	20-11-13
			Powdercoat - 4 - B4B	
			Powdercoat - 5 - B4B	
			Powdercoat - 6 - B4B	
			Powdercoat - 7 - B4B	
			Powdercoat - 8 - B4B	
			Powdercoat - 9 - B4B	
			Powdercoat - 10 - B4B	
170 QC 3	6 pcs	0.00 0.00	QC 3 - 10	
			QC 3 - 13	
			QC 3 - 15	
			QC 3 - 17	
			QC 3 - 18	
			QC 3 - 2	
			QC 3 - 28	
			QC 3 - 3	

			QC 3 - 30	
			QC 3 - 34	
			QC 3 - 36	
			QC 3 - 41	
			QC 3 - 51	
			QC 3 - 58	DAS 58 9-89 NOV 26 2020
			QC 3 - 59	
			QC 3 - 68	
			QC 3 - 9	
			QC 3 - 40	
			QC 3 - 19	
			QC 3 - 43	
			QC 3 - 24	
			QC 3 - 61	
			QC 3 - 81	
			QC 3 - 82	
			QC 3 - 87	NOV 26 2020
			QC 3 - 47	DAS 58 9-89
180 Small Fab - 2 - B4B	6 pcs	0.00 0.89	Small Fab - 1 - B4B	
			Small Fab - 2 - B4B	
			Small Fab - 3 - B4B	
			Small Fab - 4 - B4B	
			Small Fab - 5 - B4B	
			Small Fab - 6 - B4B	
			Small Fab - 7 - B4B	
			Small Fab - 8 - B4B	
			Small Fab - 9 - B4B	
			Small Fab - Various 1 - B4B	
190 QC 5	6 pcs	0.00 0.00	QC 5 - 10	
			QC 5 - 12	
			QC 5 - 17	
			QC 5 - 18	
			QC 5 - 19	
			QC 5 - 22	
			QC 5 - 24	
			QC 5 - 3	
			QC 5 - 43	
			QC 5 - 49	
			QC 5 - 51	
			QC 5 - 58	
			QC 5 - 68	
			QC 5 - 9	
			QC 5 - 50	
			QC 5 - 30	
			QC 5 - 40	DAS 40 9-89 NOV 27 2020
			QC 5 - 61	
			QC 5 - 81	
			QC 5 - 82	
200 Packaging 3-1 - Stock - B4B	6 pcs	0.00 0.00	Packaging 3 - 1 - B4B	
			Packaging 3 - 2 - B4B	
			Packaging 3 - 3 - B4B	
			Packaging 3 - 4 - B4B	DAS 28 9-89
			Packaging 3 - 5 - B4B	
			Packaging 3 - 6 - B4B	
			Packaging 3 - 7 - B4B	
			Packaging 3 - 8 - B4B	NOV 27 2020
			Packaging 3 - 9 - B4B	
			Packaging 3 - 10 - B4B	

				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
				Packaging 3 - 37 - B4B	
210 QC 21 - SA	6 pcs	0.00 0.00		QC 21 - SA - 21	DAS 21 NOV 27 2020
				QC 21 - SA - 70	9-89
				QC 21 - SA - 9	
				QC 21 - SA - 77	
				QC 21 - SA - 28	

Part Op 100 - (Bandsaw) Cut blanks: 12.150" long
 Descriptions: 110 - (HAAS CNC Vertical Machine) 1- Mill as per Folio FA297 Rev: AA & Dwg D3179-1 Rev: E
 120 - (QC2- Inspect parts off machine FAI/FAIB)
 130 - (QC8- Inspect parts - second check)
 140 - (Chemical Conversion Coat per QSI005 4.1)
 150 - (QC7-Inspect Chemical Conversion Coat)
 160 - (White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum) START TIME: _____
 170 - (QC3- Inspect Part Finish)
 180 - (Small Fab) Assemble as per Dwg D3179
 190 - (QC5- Inspect part completeness to step on W/O)
 200 - (Identify as per dwg & Stock Location: _____)
 210 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D6201	T Extrusion	6.0750 ft (1.0125 ea)	100-Bandsaw - 1	5295825
D2372 117	Quick Release	12 pcs (2 ea)	180-Small Fab - 2 - B4B	5314091
D2444 127	Pip Pin Assembly	6 pcs (1 ea)	180-Small Fab - 2 - B4B	5314091 XS
MS21042L3 57305	Nut	6 Ea (1 ea)	180-Small Fab - 2 - B4B	5309678
MS27039-1-13 5728	Screw	6 Ea (1 ea)	180-Small Fab - 2 - B4B	5309672
NAS1149D0332 5706	Washer	18 Ea (3 ea)	180-Small Fab - 2 - B4B	5306109

5293133

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
100-Bandsaw - 1 180-Small Fab - 2 - B4B	D6201	6	20	0
	D2372	12	9	0
	D2444	6	9	0
	MS21042L3	6	1,014	0
	MS27039-1-13	6	108	0
	NAS1149D0332J	18	869	0
Part Specifications				
Specifications could not be found.				

Plex 10/1/20 12:51 PM Dart.lajeunesse.marie

DART AEROSPACE LTD		Work Order: 213689
Description: Fwd Litter Tie Down Bracket		Part Number: D3179-1
Inspection Dwg: D3179	Rev: E	Page 1 of 1

INSPECTION SHEET

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.00	+/-0.030	1.000	✓		MJP-04	VIVA
R0.40	+/-0.030	0.400	✓			
R0.38	+/-0.030	0.380	✓			
1.70	+/-0.030	1.700	✓			
Ø0.191	+0.005/-0.001	0.191	✓			
10.500	+/-0.010	10.500	✓			
4.250	+/-0.010	4.250	✓			
Ø0.246	+0.005/-0.001	0.246	✓			
1.50	+/-0.030	1.500	✓			
0.750	+/-0.010	0.750	✓			
1.000	+/-0.010	1.002	✓			
4.00	+/-0.030	4.000	✓			
1.00	+/-0.030	0.999	✓			
1.38	+/-0.030	1.380	✓			
1.875	+/-0.010	1.875	✓			
2.125	+/-0.010	2.125	✓			
2.88	+/-0.030	2.88	✓			
3.31	+/-0.030	3.310	✓			
R0.375	+/-0.010	0.374	✓			
R0.50	+/-0.030	0.500	✓			
Ø0.191	+0.005/-0.001	0.192	✓			
R0.25	+/-0.030	0.250	✓			
R0.375	+/-0.010	0.375	✓			
R0.38	+/-0.030	0.380	✓			
12.00	+/-0.030	12.000	✓			
9.000	+/-0.010	9.000	✓			
7.50	+/-0.030	7.500	✓			
4.50	+/-0.030	4.500	✓			
2.88	+/-0.030	2.875	✓			
2.250	+/-0.010	2.250	✓			
1.000	+/-0.010	0.997	✓			
0.50	+/-0.030	0.498	✓			

Measured by: 33 9-89	Checked by: J.C.L.	QC Inspector:
Date: 20/10/21	Date: 20-10-23	Date:

Engineering Approval: (If necessary)	Date:
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Rev	Date	Change	Revised by	Approved
A	09.04.05	New Issue P/O D3179-041	KJ/DD	
B	12.10.04	Dimension 0.750 was 1.750	KJ	
C	13.05.27	Dimensions revised per Dwg Rev D	KJ	
D	16.06.08	Dimensions revised per Dwg Rev E	KJ	
E	17.02.16	Dimensions rearranged	KJ	

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					